

Date: Monday, 27/04/2009 7:33:18 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 47479	
Estimate Number : 13886	
P.O. Number :	Part Number : D38861
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3886 PREL
Prsht Rev. : NC	Project Number : LG0012
First Issue : / / Type : MACHINED PARTS	Drawing Revision : PREL
Previous Run :	Material :
Written By : <u>JLM 09-04-27</u>	Due Date : 04/05/2009
Checked & Approved By :	
Comment : Est Rev:A New Issue 09-04-27 JLM Verified By:EC	



6 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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Comment: Qty.: 0.1969 f(s)/Unit Total : 1.1813 f(s)
 304 BAR
 Material: 304/316 SS Bar
 (M304B0.500x02.500)
 Identify for D3414-3
 Batch: M111330

CERTIFICATE OF CONFORMITY
 REQUIRED

J.A 09/05/11

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.50" x 0.500" x 2.250" long

J.A 09/05/11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA812 and Dwg D3886
 Identify as D3886-1
 Dwg Rev B Folio Rev AA

J.L 09/05/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/05/12

5.0	QC8	SECOND CHECK
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ENGINEERING
 APPROVAL

RA 09.09.02

Comment: SECOND CHECK

SL 09/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3886-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 05-05-11

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47479</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/11	3.0	1 part scrap The blank is holding in Jaws by .070". The mat is not square so the 1" rougher got it to jump out of jaws	[Signature]	face both ends of blank to make it square and sit right flush in jaws	N.A 09/05/11	[Signature] 05-05-11	[Signature] 05-05-11	[Signature] 05-05-11

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 47479

Part Number: D38861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A x B

4XB47819

STORE FN ENG'S SHED

ENG USE ONLY

RF 09-09-02

EL 9-6-05

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

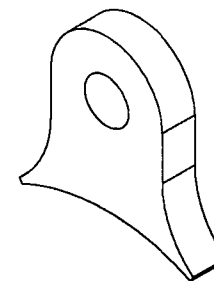
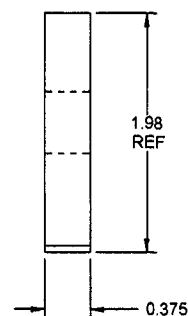
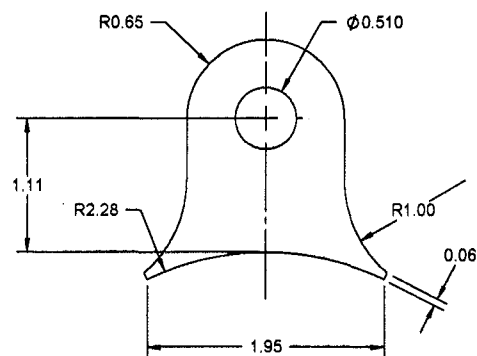


POSITIVE RECALL

EFFECTIVE 9-8-11 AUTH LC

RELEASED RF DATE 09-09-02

MF 09-06-02



D3886-1 LUG

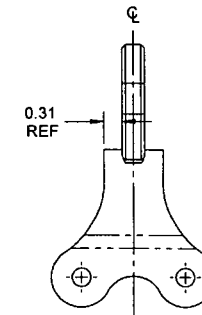
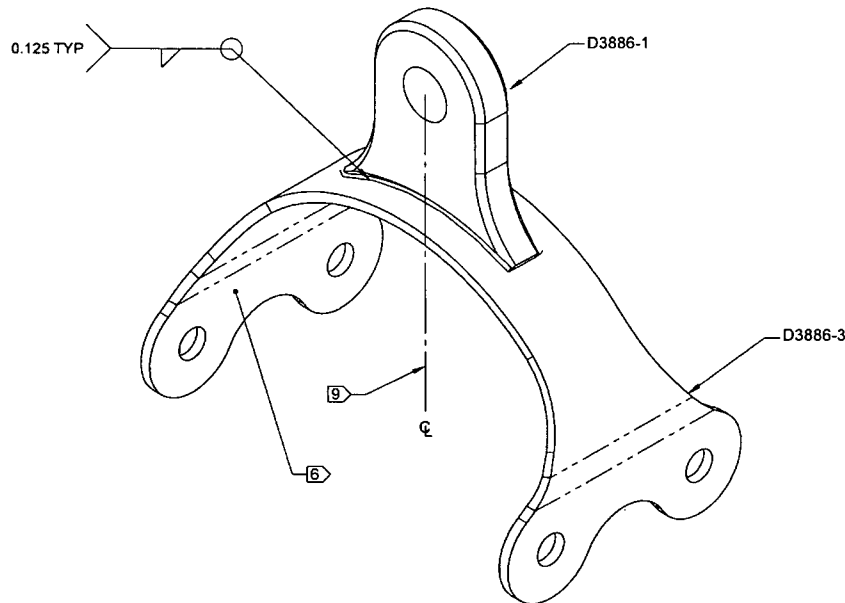
PRELIMINARY
09.05.12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3886	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LUG ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

ITEM	QTY	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



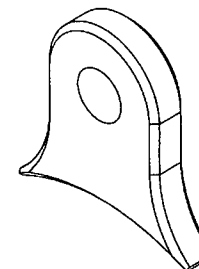
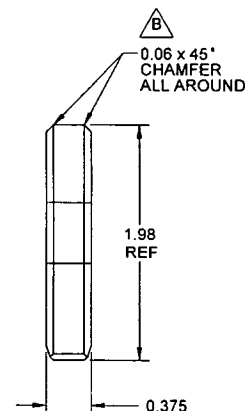
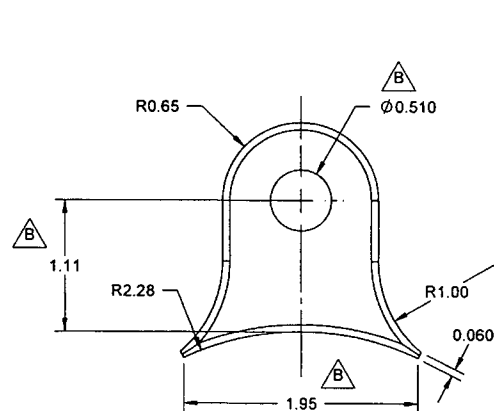
D3886-041 LUG ASSEMBLY

47479
RELEASED
 9/27/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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D3886-1 LUG

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

RELEASED
07/15/11

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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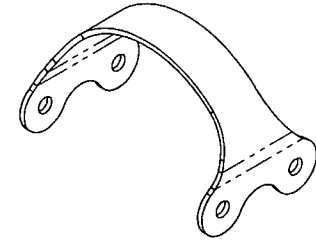
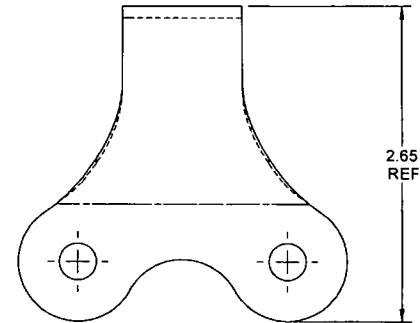
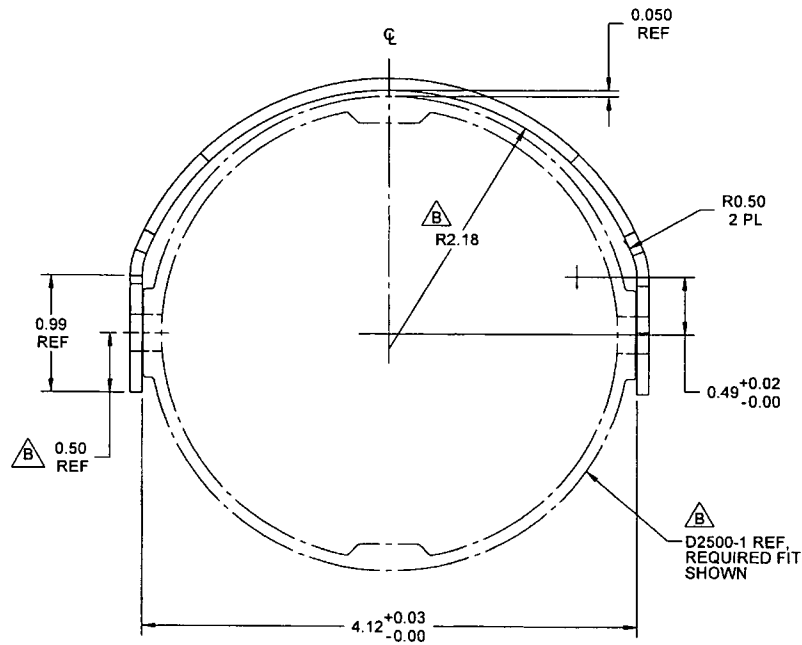
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

A

D3886-3 BRACKET B
(MAKE FROM D3886-3F)

47477

RELEASED
21/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

